

Data	Intake valve		Exhaust valve	
Engine	615	616, 617	615	616, 617
Valve head dia.	38.7–38.9	39.7–39.9	33.1–33.3	34.1–34.3
Valve stem dia.	9.92–9.94			
Valve length	131.3–131.7		130.8–131.2	
Code in stem end	E 615 01	E 616 02	A 615 04	A 616 05
Sodium filling	none			
Valve seat casing	nitrided in bath			
Heighth "h" of valve head	as new	2.34	2.01	
	tolerance limit	1.5	1.5	
Adjusting angle for valve refacing	30° + 15'			
Permissible eccentricity at valve stem and valve seat max.	0.03			

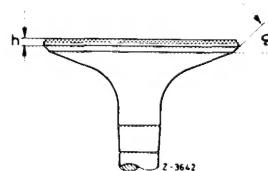
Commercially available tools

Valve head grinder
or
valve head cutter e.g. Matra-Werke GmbH
6000 Frankfurt/Main 8
e.g. Hunger, 8000 München

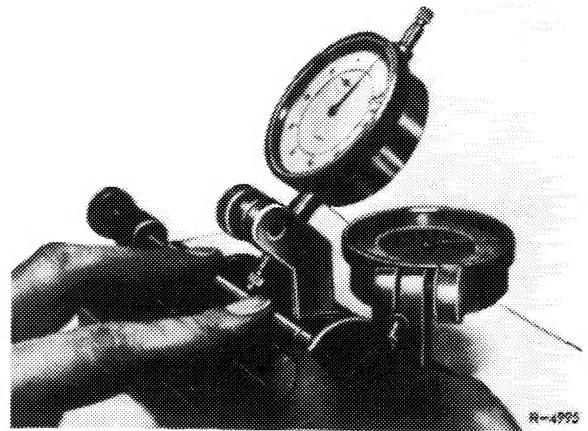
Checking and refacing

1 Clean valves and sight-check.

All valves with burnt cylinder heads, with inadequate valve head height "h" and with worn or scored valve stems are to be replaced.



2 Measure valve stem eccentricity. Replace valve if eccentricity exceeds 0.03 mm.



R-4995

3 Reface valve seat.

Note instructions for use of machine, and adhere to 30° adjustment.

4 Measure valve seat eccentricity and valve head height "h".

Replace valve if tolerance limits are reached.

